

Work Order ID 79363

79363

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Wednesday, January 25, 2012 12:26:44 PM

Item ID: D3290-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Window
 Start Date: 1/25/2012 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 2/3/2012 Req'd Qty: 5.00 *5* Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/01/25 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3290	Rev C								

100 0.00
 100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3290 Dwg Rev: C Prog Rev: C 2-
 Deburr if necessary

B12-2-10
 (9)

110 0.00
 110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

B12-2-10

120 0.00
 120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

(89)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79363

Wednesday, January 25, 2012 12:26:44 PM

N900040100

Setup Start *NS1*

Stop *NS2*

5

5

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

130

0.00

130

HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

Thermoforming Machine

Without removing protective skin remove sharp edge by degurring.

140

0.00

140

THERMOFORMING MACHINE

0.00

Thermoform

Memo

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Folio FTA001 Dwg.
Rev. C Folio Rev B 2-Engrave part# &
batch#, (D3290-3)

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

Memo

0.00

QC

Quality Control

W/O: 793603		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 23290-3 PAR #: _____ Fault Category: Thermofining NCR: Yes ☒ No ☐ DQA: [Signature] Date: 12/31
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 12/31

NCR: 12-1231		WORK ORDER NON-CONFORMANCE (NCR) # 49.75						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/02/13	140	BLISTER 10 SHEET. Process	GP 12.2.27 05/04/12	Scrap 1 part	Sh 12/02/13	mhl 12/02/27	GP 12.2.27 05/04/12	mhl 12/02/27

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Required Date: 2/3/2012 Req'd Qty: 5.00 ***5*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00							
170	HAND FINISHING THERMOFORMING								
Thermoform	Memo	0.00							
Thermoforming Machine	Water sand and buff to remove scratches if required								
180		0.00							
180	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
190		0.00							
190	Identify as per dwg & Stock Location: <u>Store</u>								
Packaging	Memo	0.00							
Packaging									

Handwritten: X7 OK 12/02/15 PTO →

Handwritten: 12 02 24 7

Handwritten: SPD 12-02-25

W/O: 79363		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3290-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/02/21	170	Several Small Blisters Overheated.		Scrap 1 part	DE 12/02/21			ME 12.02.21

NOTE: Date & initial all entries

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Required Date: 2/3/2012 Req'd Qty: 5.00 *5* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/2/27

12-02-27
(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, January 25, 2012 12:26:48 PM

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Work Order ID: 79363

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Parent Item: D3290-3

D3290-3

Parent Item Name: Window

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP A04.08.18New issueKJ/RF
 IPP B06.05.09Ecn 798 EC IPP Rev.
 C Removed QC8 Step 160 11/04/11 DL
 IPP C 07.05.29. Thermoform in-house DL
 IPP D 07.09.28 rev C dwg EC verified by: DD
 IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	225.2634	3	15.78947		32,	

MACRI ICS 125

1/8" Polycast II Sheet

B 12-2-10

Location

Loc Qty

Loc Code

MAT019

225.2634

110633

8

117324

0.2467

117431

10.7967

119591

206.22

119591

9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

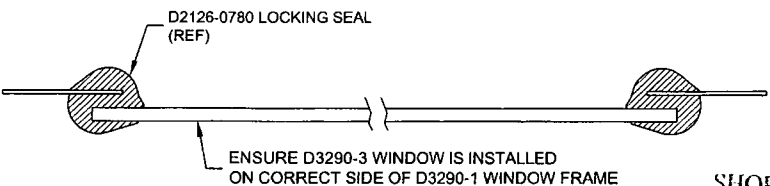
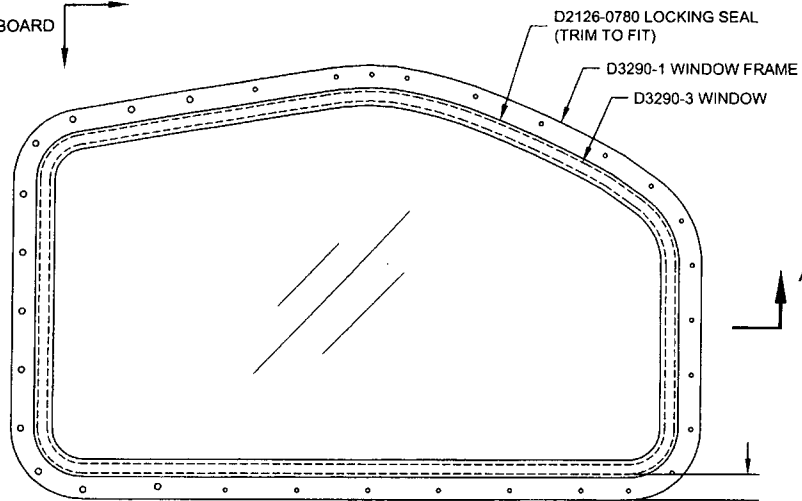
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

FWD
INBOARD



SECTION A-A
NTS

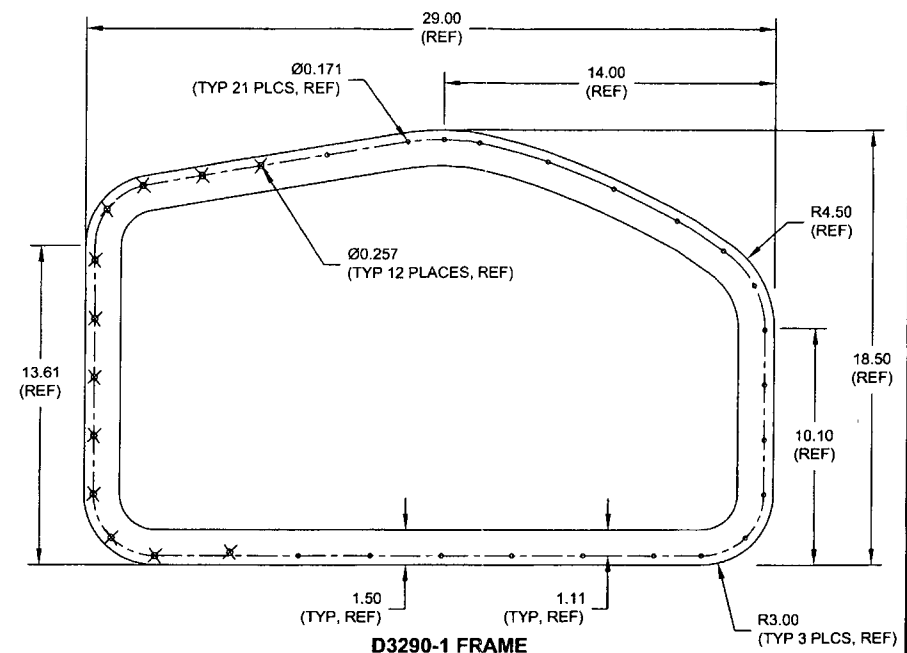
D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:
1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
2) UNITS: INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURNED
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT THE
WORK ORDER
NO. 79363
12/01/25

UNDER REVIEW
44.5
4/29/07-18
7/12/07-05
6/12/09



D3290-1 FRAME

- D3290-1 NOTES:**
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
5) WEIGHT: 0.47 LBS

RELEASED
07.09.22
DEO ATTACHED

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3290	REV. C SHEET 1 OF 2
TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
COPYRIGHT © 2004 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

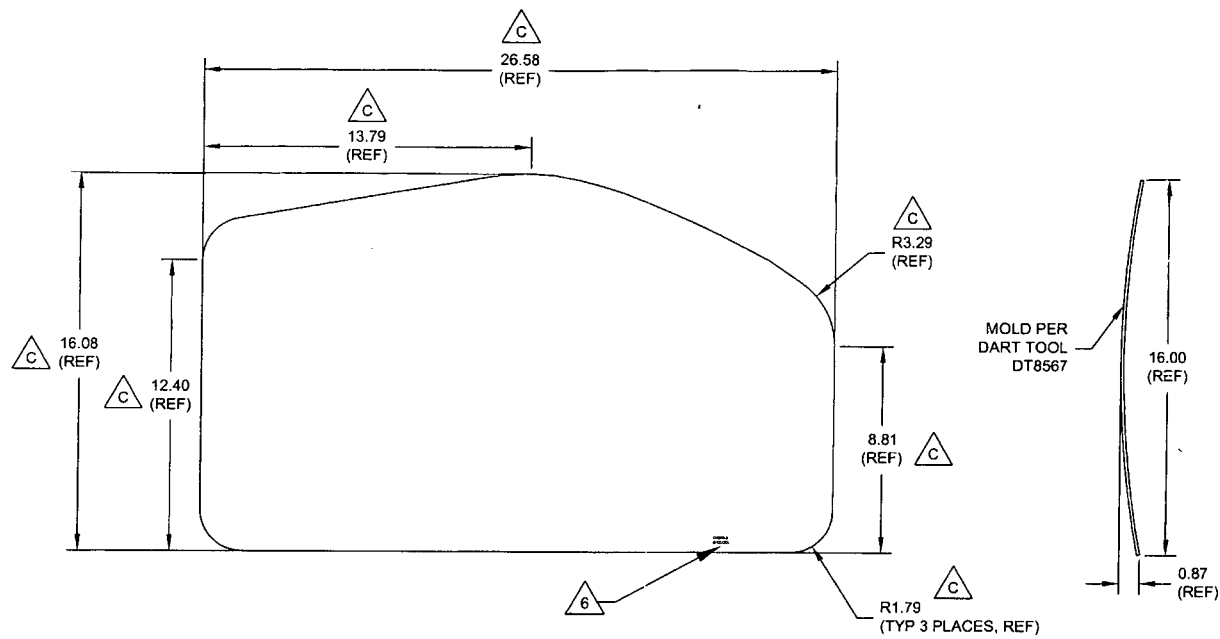
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D3290-3 WINDOW

- D3290-3 NOTES:**
- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) REMOVE SHARP EDGES
 - 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
 - 7) WEIGHT: 1.87 +/- 0.42 LBS
 - 8) MOLD PER DART TOOL DT8567

W. J. H. 1/10/19

UNDER REVIEW

DEO ATTACHED

RELEASED

07.07.22

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D3290 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>97</i>	CHECKED <i>1</i>	MFG. APPR. <i>E</i>	APPROVED <i>AD</i>		DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09
WMP

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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